

Date: Wednesday, 4/5/2006 8:07:11 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 1/4 TURN FASTNER RAIL (BLACK)
Job Number	: 26486		
Estimate Number	: 10096	Part Number	: D103858B
P.O. Number	: N/A	Drawing Number	: D1038
This Issue	: 4/5/2006 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: B
First Issue	: 4/4/2006 Type : MACHINED PARTS	Material	: N/A
Previous Run	: N/A	Due Date	: 4/21/2006
Written By	: <i>See comment below</i>	Qty:	80 Um: Each
Checked & Approved By	: <i>06.04.04</i>		
Comment	: Est: 03.05.02 Reformat; Added label KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL  
 Create white labels and bag them

2.0	D2023	Extrusion, Fastener Rail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)  
 Extrusion, Fastener Rail  
 Batch: *21907*

*J.F. 06/04/19 80*

3.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

*J.F. 06/04/19 80*

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Machine as per Folio and Dwg D1038-58

*me 06/04/20 80*

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*me 06/04/20 80*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS

06/04/21

80

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

FB

06-05-01

80

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES,



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: P.O. 1138

Black Anodize as per Dwg D1038

20105102 (80)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

P.O. 1138

80

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

06-05-11

80

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389

Batch: 14050

2-Grind wire flush and deburr

3-Clean

SAD 06-05-14

80

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-16

80

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-05-02	7.0	Add Q65 permanent change. <i>Z</i>					<i>Z</i>	
		<hr/> Inspect Q65	<i>Z</i>	06-05-02		<i>u</i>		
06-05-11	8.0 10.0	Anodize to mill spec Mil-AB625 F1 Type II Class 2 Add to steps 8 & 10. Mill spec should be written on the Dwg. for P/O inspection. permanent change. <i>Z</i>				<i>u</i>	<i>Z</i> 06-05-11	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: *RD* Date: 06/05/16 <sup>79</sup>  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-16	11	Part scrap. <del>End</del> and punched too hard and bent the corner, and damaged the mat'l.	<i>[Signature]</i>	Scrap: destroy	SAD 06-05-16	<i>[Signature]</i> 06-05-16	<i>[Signature]</i>	<i>[Signature]</i> 06-05-16

NOTE: Date & initial all entries

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Part Number: D103858B

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Taper ends to close cardboard tubes

3-Apply white labels to cardboard tubes

4-Identify and Stock

Location: FG47

*GA*

05.06.16

49

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DP*

06/05/16

79

Job Completion



U 06-05-16

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

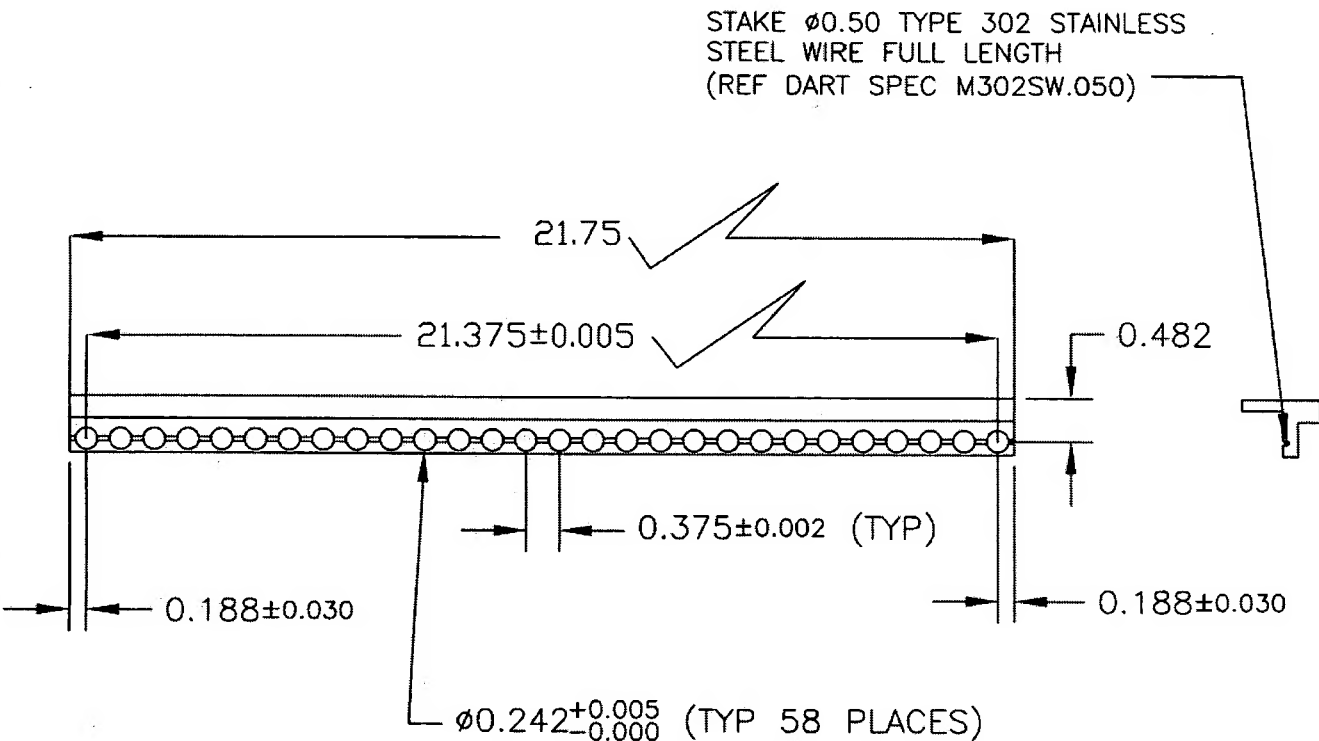
**NOTE:** Date & initial all entries



**DART**

RELEASED

05.03.31



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
04	04	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
04	04	D1038	
DATE		TITLE	SCALE
05.02.02		1/4 TURN FASTENER RAIL	NTS
	91.05.05	NEW ISSUE	
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	

**D1038-58 1/4 TURN FASTENER RAIL**

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE  
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 2648.6

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**TNM****ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

47556

08-May-2006

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE****CERTIFICAT DE CONFORMITE****PURCHASE ORDER/****NO. DE COMMANDE:****PO00001138**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
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1	80	80	D103-858-B	AVIONICS FASTENER RAIL
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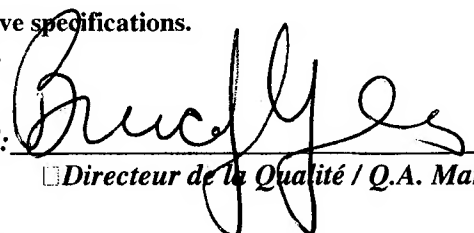
MATL: AL

BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

**REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL**

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.  
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: ☐ Directeur de la Qualité / Q.A. Manager ☐ ☐ ☐